

Work Order ID 51820

September 4, 2009 8:37:19 AM



Page 1

Item ID:	D3847-043	Accept		Setup	Start	
Revision ID:	B					
Item Name:	FWD WEARPLATE ASSY, STD/ FLOAT GEAR				Stop	
Start Date:	09/04/2009	Start Qty:	4.00			
Required Date:	09/11/2009	Req'd Qty:	4.00			
				Cust Item ID:		
				Customer:		

Reference:

Approvals:	Process Plan:	<u>MF</u>	Date:	<u>09-09-04</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3847	B								
100		0.00							
Waterjet									
FLOW CNC Waterjet	304 250								
	Memo	0.00							
	1-Cut as per Dwg D3847								
	Dwg Rev: <u>B</u>								
	Prog Rev: <u>B</u>								
	2-Deburr if necessary								
110									
	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC									
Quality Control	Memo	0.00							

LB 9-9-25

LB 9-9-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51820

September 4, 2009 8:37:19 AM



Page 2

Item ID: D3847-043

Accept



Setup Start



Revision ID: B

Stop



Item Name: FWD WEARPLATE ASSY, STD/ FLOAT GEAR

Start Date: 09/04/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

SB 09/09/25



QC

Memo

0.00

Quality Control



130

Brake NC
Memo
form as per dwg D3847

0.00

0.00

SB 09/09/28



Brake NC



Brake NC

140

QC5- Inspect part completeness to step on W/O

0.00

0.00

SB 09/09/28



QC

Memo

Quality Control



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 51820

September 4, 2009 8:37:19 AM



Page 3

Item ID: D3847-043

Accept



Setup Start



Revision ID: B

Stop



Item Name: FWD WEARPLATE ASSY, STD/ FLOAT GEAR

Start Date: 09/04/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

M108091
START 9:00AM
Temp: 320°F
FIN: 9:30AM

0.00

→ M 09/09/29

(X5) 0

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

→ M 09-09-29

5

170



Small Fab

Small Fab

Memo

1- Bond gasket to inner surface of wearplate using a thin layer of 3m
1300/1300L scotch grip adhesive as per dwg D3847

0.00

0.00

BATCH: M111428

→ 09/10/06 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 4, 2009 8:37:19 AM

Page 1

Work Order ID: 51820

Parent Item: D3847-043RevB

Parent Item Name: FWD WEARPLATE ASSY, STD/ FLOAT GEAR



Start Date: 09/04/2009

Required Date: 09/11/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3846-3RevB 		Manufactured	No				Each	0.0000	4.0000	B 51829		
GASKET M304S18GA 		Purchased	No				sf	183.4395	4.5474	56842		
304/316 .050 Sheet												

EP 09/10/06

189-9-17

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	183.4395053	
108156	0.98526316	
111743	23.7174	
112178	158.736842	

112178

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 51820
Description: FWD WEARPLATE ASSY STD/FLOAT GEAR		Part Number: D3841-043
Inspection Dwg: D3841-3 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

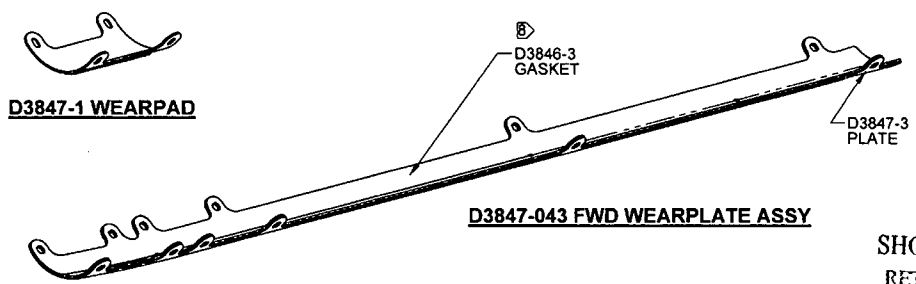
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6 .188	+ .005 - .001	.192	*			
.300	+/- .010	.353	*			
.300	+/- .010	.305	x			
3.280	+/- .010	3.272	λ			
2.45	+/- .030	2.451	*			
4.13	+/- .030	4.126	*			
1.69	+/- .030	1.691	x			
.75	+/- .030	.746	x			
6.88	+/- .030	6.878	x			
10.000	+/- .010	10.000	*			
18.000	+/- .010	18.000	x			
39.53	+/- .030	39.53	x			
14.484	+/- .010	14.484	*			
28.967	+/- .010	28.964	*			
32.467	+/- .010	32.467	*			
33.967	+/- .010	33.967	*			
37.467	+/- .010	37.467	x			
.050	+/- .010	.046	>			

Measured by: AB	Audited by: S	Prototype Approval:	N/A
Date: 9-9-24	Date: 09/09/25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

8 7 6 5 4 3 2 1

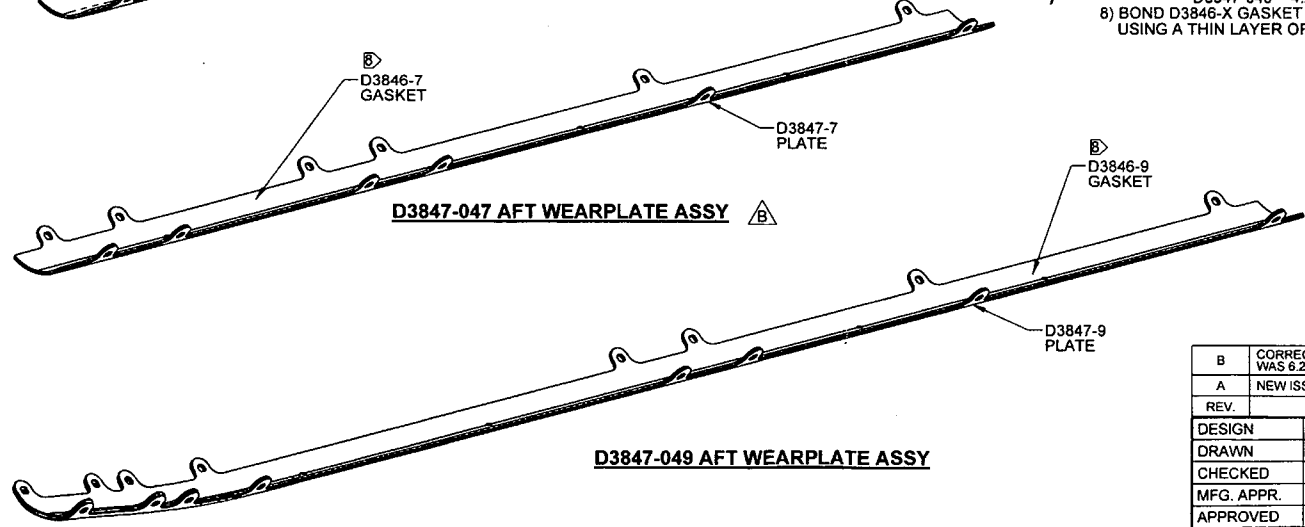
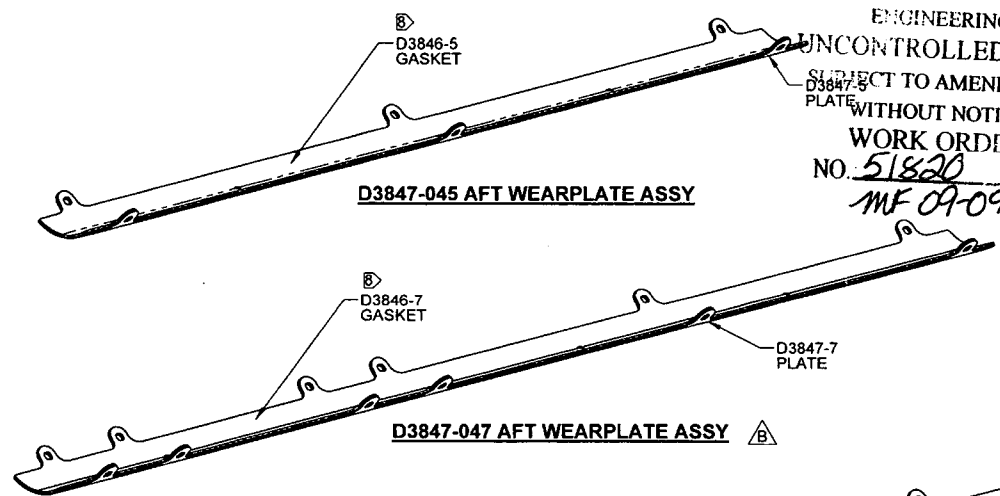


ITEM	QTY -043	QTY -045	QTY -047	QTY -049	P/N	DESCRIPTION
1	X				D3847-043	FWD WEARPLATE ASSY, STD/FLOAT GEAR
2		X			D3847-045	CENTER WEARPLATE ASSY, STD/FLOAT GEAR
3			X		D3847-047	AFT WEARPLATE ASSY, STD GEAR
4				X	D3847-049	AFT WEARPLATE ASSY, FLOAT GEAR
11	1				D3847-3	PLATE
12		1			D3847-5	PLATE
13			1		D3847-7	PLATE
14				1	D3847-9	PLATE
15	1				D3846-3	GASKET
16		1			D3846-5	GASKET
17			1		D3846-7	GASKET
18				1	D3846-9	GASKET
31	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 51820
MF 09-09-04

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3847-XXX" USING YELLOW PAINT MARKER AT INSIDE SURFACE
 - 7) WEIGHT: D3847-043 = 1.71 lbs
D3847-045 = 1.49 lbs
D3847-047 = 2.00 lbs
D3847-049 = 4.21 lbs
 - 8) BOND D3846-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE



RELEASED
09/15/15

B	CORRECT TYPO D3847-047 WAS D3847-045. ZN B5-1: 5.82 WAS 6.25 (ZN A4-2); 45.28 WAS 45.71 (ZN B4-5)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3847	SHEET 1 OF 7
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	WEARPLATE ASSY	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

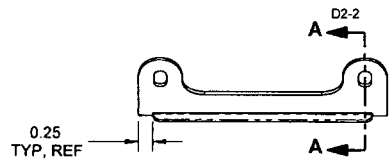
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

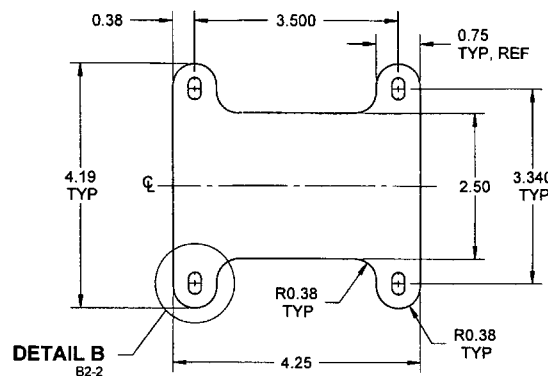
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

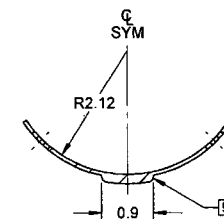
W/O 51820



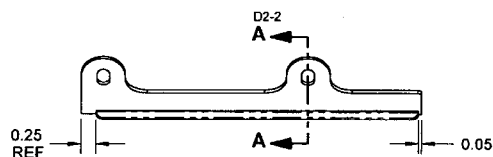
D3847-1 WEARPAD
MADE FROM D3847-1F FLAT PATTERN



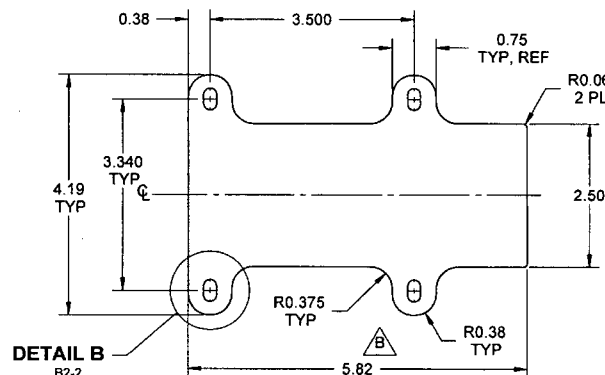
D3847-1F FLAT PATTERN



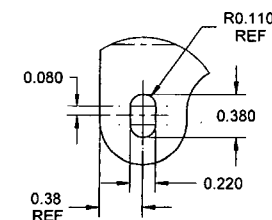
SECTION A-A D7-2 B7-2



D3847-11 WEARPAD
MADE FROM D3847-11F FLAT PATTERN



D3847-11F FLAT PATTERN



DETAIL B CS-2 BS-2
TYP. SCALE 2X

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK), (REF. DART SPEC. M304S16GA)
- 2) FINISH: POWDER COAT "GREY SANDEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3847-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT:
D3847-1 = 0.03 lbs
D3847-11 = 0.47 lbs
- 8) WELD PER QSI 004
- 9) APPLY 2 LAYERS OF 2059B HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.19 TO 0.25 THICK UNLESS OTHERWISE INDICATED

RELEASED
12/15/10

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3847	SHEET 2 OF 7
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	WEARPLATE ASSY	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC.	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

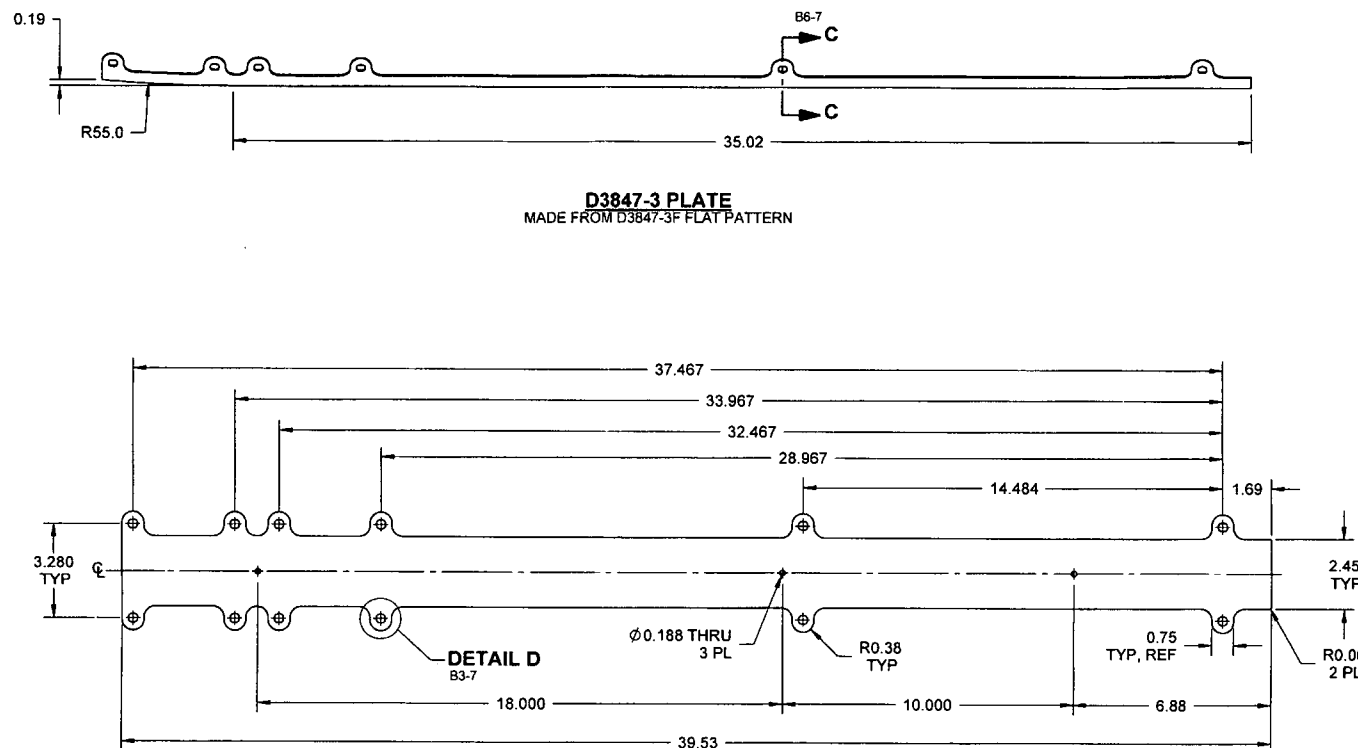
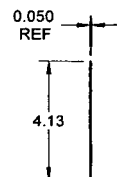
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O 51820

D3847-3 PLATE
MADE FROM D3847-3F FLAT PATTERN



D3847-3F FLAT PATTERN

RELEASED
12/17/13

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER AMS 5513 OR AMS 5524, 18 GAUGE (0.050 THICK), (REF. DART SPEC. M304S18GA)
- 2) FINISH: POWDER COAT "GREY SANDEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.46 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>EE</i>	D3847	SHEET 3 OF 7
APPROVED		TITLE	SCALE
DE APPR.	<i>PH</i>	WEARPLATE ASSY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

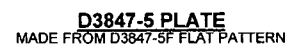
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8	7	6	5	4	3	2
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NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER AMS 5513 OR AMS 5524, 18 GAUGE (0.050 THICK), (REF. DART SPEC. M304S18GA)
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.29 lbs

RELEASED
09/07/15

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3847	SHEET 4 OF 7
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	WEARPLATE ASSY	NTS
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8 7 6 5 4 3 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

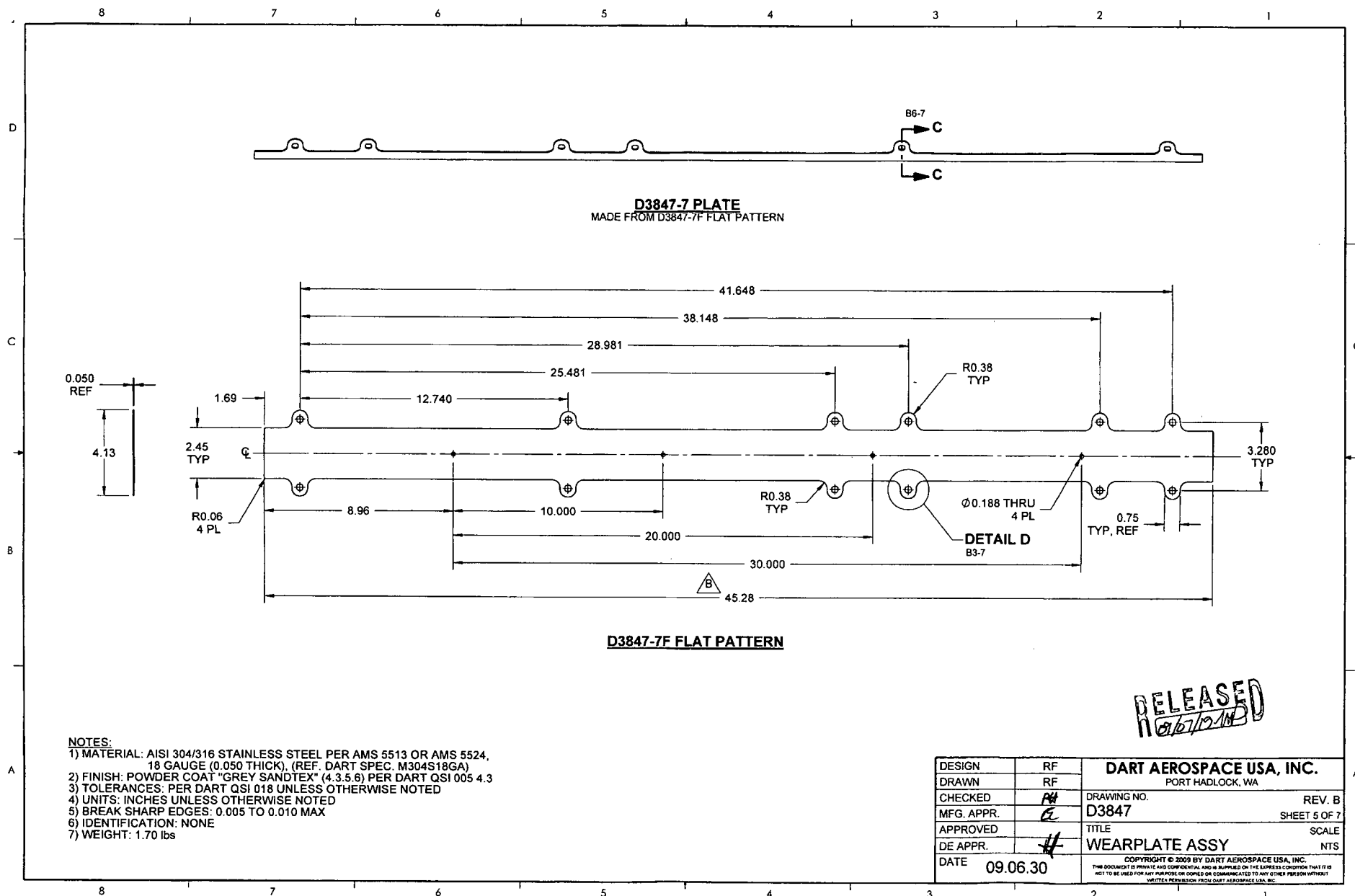
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NOTE: Date & initial all entries

W/0 51820



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

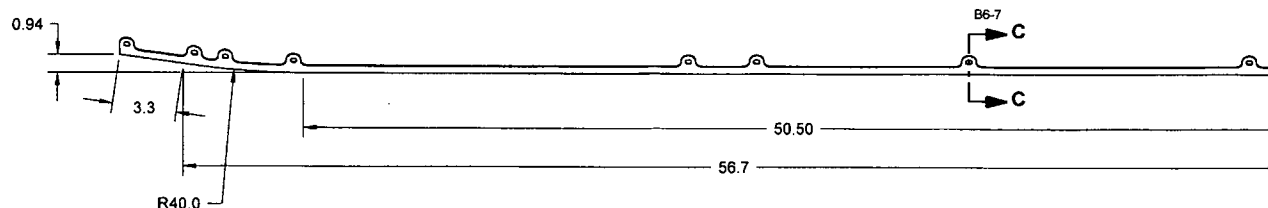
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

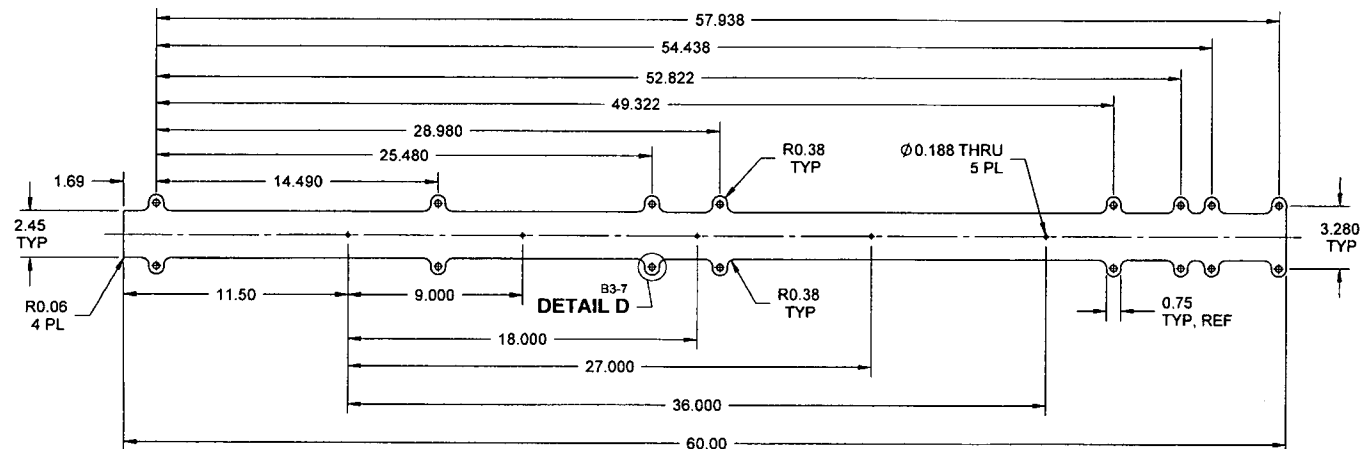
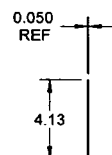
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

w/o 51820



D3847-9 PLATE
MADE FROM D3847-9F FLAT PATTERN



D3847-9F FLAT PATTERN

RELEASED
9/6/94

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER AMS 5513 OR AMS 5524, 18 GAUGE (0.050 THICK), (REF. DART SPEC. M304S18GA)
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 3.86 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>E</i>	D3847	SHEET 6 OF 7
APPROVED		TITLE	SCALE
DE APPR.	<i>#</i>	WEARPLATE ASSY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

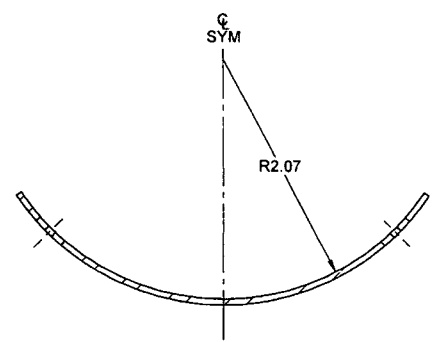
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

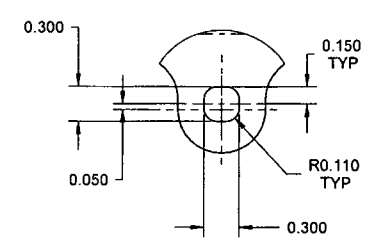
NOTE: Date & initial all entries

W/O 51820



SECTION C-C
SCALE 4X

D4-3
D4-4
D3-5
D3-6



DETAIL D
TYP, SCALE 4X

B5-3
B6-4
B3-5
B5-6

RELEASED
2967/15 M/D

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	<i>RF</i>	DRAWING NO. D3847	REV. B
MFG. APPR.	<i>RF</i>	TITLE	SHEET 7 OF 7
APPROVED		WEARPLATE ASSY	SCALE
DE APPR.	<i>RF</i>		NTS
DATE	09.06.30	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries